

Date: Friday, 18/04/2008 7:24:48 AM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SLEEVE
 Job Number : 38684
 Estimate Number : 13173
 P.O. Number :
 This Issue : 18/04/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 11 Type : MACHINED PARTS
 Previous Run : 37763
 Written By : *JLM 08.04.18*
 Checked & Approved By :
 Comment : Est Rev:A New Issue 08-02-11 JLM Verified By: *TC*

Part Number : D36891
 Drawing Number : D3689 UNDER REVIEW
 Project Number : N/A
 Drawing Revision : U/R
 Material :
 Due Date : 25/04/2008
 Qty: 2 Um: Each

Prototype

PROTOTYPE

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M303H1125 303 Hex Bar 1.125



Comment: Qty.: 0.3587 f(s)/Unit Total : 0.7174 f(s)

303 Hex Bar 1.125

Batch: ~~1113~~ 11106899

JLM 08/04/18

2

2.0 DOOSAN LATHE DOOSAN LATHE



Comment: Doosan Lathe

1- Turn as per Folio FA722 Rev. *NA* & Dwg D3689 Rev. *A*

2-Deburr per dwg D3689

JLM 08/04/18

2

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JLM 08/04/18

2

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

BF 08.04.18

(2)

5.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: *6251*

08/04/29 (2)

LPI Per ASTM 1417 LEVEL 2

Certificate of conformaty is required

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SLEEVE

Job Number: 38684

Part Number: D36891

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

Re gds

(2)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

18/04/29

(2)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

*Quarantine - 1
sample for testing - 1*

9.0

QC21

FINAL INSPECTION/W/O RELEASE



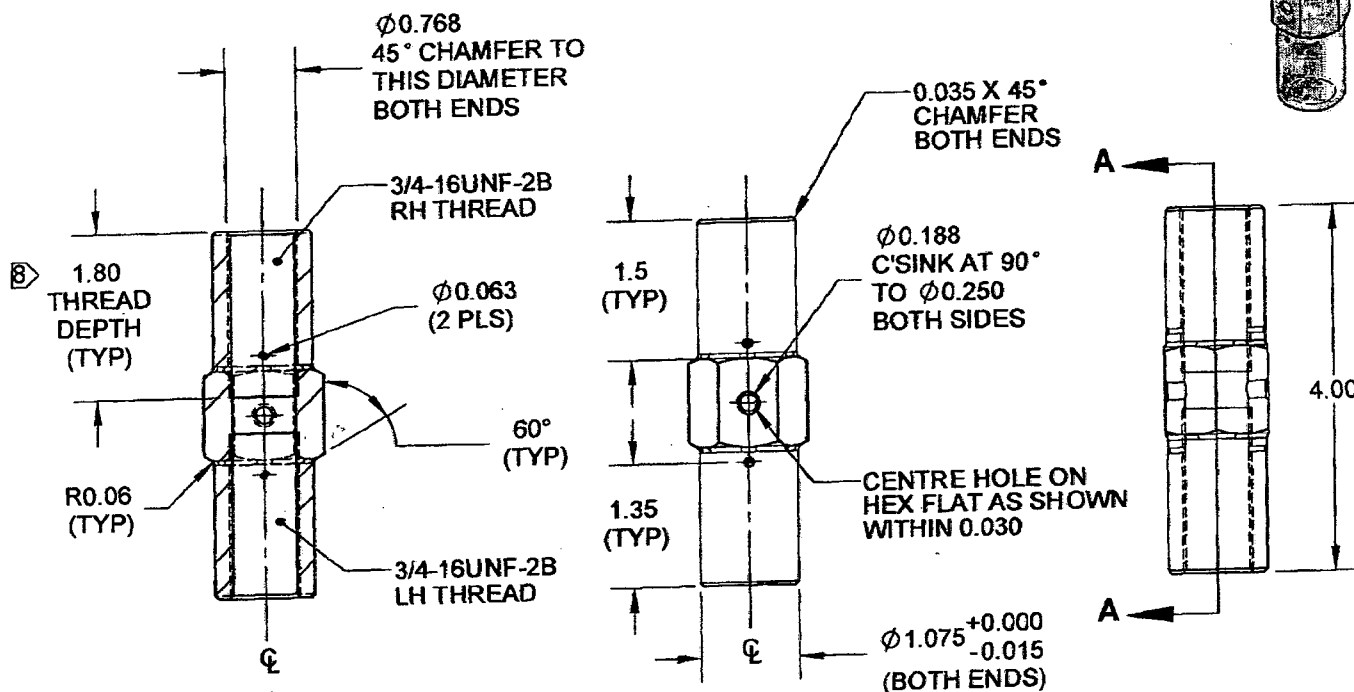
08/05/09

Comment: FINAL INSPECTION/W/O RELEASE

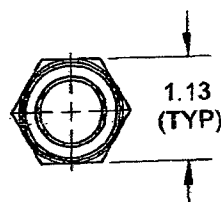
Job Completion



18/04-38



SECTION A-A



D3689-1 SLEEVE

REFERENCE ONLY
PROTOTYPE

NOTES:

- 1) MATERIAL: AISI 303 STAINLESS STEEL HEX BAR (REF. DART SPEC. M303H) OR AISI 303 STAINLESS STEEL ROUND BAR (REF. DART SPEC. M303R) OR AISI 304/316 STAINLESS STEEL ROUND BAR (REF. DART SPEC. M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.67 lb
- 8) DIMENSION SHOWN IS MINIMUM DEPTH OF FULL THREAD
- 9) LPI PER ASTM 1417 LEVEL 2

A	NEW ISSUE	RF	08.03.12
REV.		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3689	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		SLEEVE	1:2
DATE	08.03.12	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



LIQUID PENETRANT TEST REPORT

P - 1269 2

CLIENT	DART AEROSPACE	DATE	APR 28, 2008	PAGE	1	OF	1
ATTENTION	LINDA LACELLE	ACUREN JOB NO.	188 08 1269	TIME	AM <input type="checkbox"/>	PM <input type="checkbox"/>	
ADDRESS	1270 ABERDEEN ST	PO/VO No.					
	HAWKESBURY, ONT.	WORK LOCATION	HAWKESBURY				
		ACCEPTANCE STD.	ASTM 1417/QSI-038	REV./DATE	2005		
PROJECT	MACHINED PARTS.						
ITEM(S) EXAMINED	JOB # 38684 2 SLEEVES, 38687 1 STUD.						

JOB DESCRIPTION	PROCEDURE NO. LT-0002	REV./DATE	TECHNIQUE No. LT-TECH2	REV./DATE
'PART No. SLEEVE D36891/STUD D36883		MATERIAL	303	THICKNESS
SCOPE WET FLOURESCENT LIQUID PENETRANT INSPECTION CARRIED OUT ON 100% ACCESSIBLE SURFACE				

TEST DETAILS

METHOD	<input checked="" type="checkbox"/> FLUORESCENT	<input type="checkbox"/> VISIBLE	<input checked="" type="checkbox"/> WATER WASH	<input type="checkbox"/> SOLVENT REMOVABLE	<input type="checkbox"/> POST EMULSIFIED
FAMILY BRAND	MAGNAFLUX		BLACK LGHT8171	<input type="checkbox"/> OUTPUT > 1000 μ W/CM ²	<input type="checkbox"/> AMBIENT < 2 fc
PENETRANTZL67	MINIMUM DWELL TIME	45 MIN.	LIGHTING EQUIP.	<input type="checkbox"/> FLASHLIGHT	<input type="checkbox"/> TROUBLELIGHT
PENETRANT REMOVER H2O	MINIMUM DRY TIME	>10 MIN.	OTHER	CAL FEB 12 08	
DEVELOPER SKDS2	MINIMUM DWELL TIME	10 MIN.	LIGHT METER S/N	CAL DUE DATE	
DEVELOPER TYPE	<input checked="" type="checkbox"/> NON AQUEOUS	<input type="checkbox"/> AQUEOUS	<input type="checkbox"/> DRY		

TEST SURFACE

SURFACE CONDITION	<input type="checkbox"/> AS GROUND	<input type="checkbox"/> AS WELDED	<input type="checkbox"/> MACHINED	<input type="checkbox"/> SHOT BLASTED	<input checked="" type="checkbox"/> CLEAN BARE METAL
SURFACE TEMPERATURE	<input type="checkbox"/> < - 4°C/ 20°F	<input type="checkbox"/> - 4°C/ 20°F TO 10°C/50°F	<input type="checkbox"/> 10°C/50°F TO 52°C/125°F	<input type="checkbox"/> > 52°C/125°F	

RESULTS- (☐ METRIC ☒ IMPERIAL)

FLUORESCENT LIQUID PENETRANT INSPECTION

CARRIED OUT ON 100% ACCESSIBLE

SURFACE ON:

38684 P/N D36891 2 SLEEVES.

38687 P/N D36883 1 STUD.

RESULTS: NO INDICATION OF DEFECTS.

ITEMS ACCEPTABLE TO STANDARD

Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner operator and the owner operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE		SIGNATURE	DTR # E19656
TECHNICIAN (SIGNATURE):			REPORT REVIEWED BY:
NAME (PRINT):	JASON HEWETT		NAME INITIALS
	1 ST TECHNICIAN	2 ND TECHNICIAN	
CGSB LEVEL	2	SNT LEVEL	
CGSB REG. No	6156	CGSB REG. No	

WHITE - CLIENT COPY

CANARY - OFFICE COPY

PINK - TECHNICIAN COPY

GOLD - OFFICE COPY